

Tuesday, 9/4/2007 11:30:07 AM  
Kim Johnston

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: SHUT-OFF VALVE SHAFT
Job Number	: 34411		
Estimate Number	: 12180		
P.O. Number	: N/A	Part Number	: D34705
This Issue	: 9/4/2007	S.O. No.	: N/A
Prsht Rev.	: NC	Drawing Number	: D3470 REV.A
First Issue	: N/A	Project Number	: N/A
Previous Run	: 26987	Drawing Revision	: A
		Material	: N/A
Written By	: <u>                    </u>	Due Date	: 10/4/2007
Checked & Approved By	: <u>                    </u>	Qty:	6 Um: Each
Comment	: est rev A 06.04.20 new issue EC		

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description:
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1.0	M304S26GA	304/316 0.018 SHEET
-----	-----------	---------------------



Comment: Qty.: 0.0656 sf(s)/Unit Total: 0.3938 sf(s)

304/316 0.018 SHEET

Batch: M 105490 1807-09-6

2.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET

Cut as per Dwg D3470

Dwg Rev: AProg Rev: A1807-09-6(P10) →

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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1807-09-6

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
-----	-----	--------------



Comment: SECOND CHECK

En 07/09/06 (+6) counter

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL &amp; MEDIUM FAB RESOURCE 1

Deburr if necessary.

En 07/10/22 (+6)

6.0	QC5	INSPECT WORK TO CURRENT STEP
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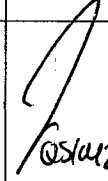
Comment: INSPECT WORK TO CURRENT STEP

En 07/10/22 (+6)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: ☒ Date: 07/10/06

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
07/09/06	#	Two (2) parts scrap 1- the drill holes are egg shaped 2- small cutout on outside profile. P.C. operator error		Scrap and destroy and replace	07-09-06 JE	Er 07/09/06		Er 07/09/06

NOTE: Date & initial all entries

Date: Tuesday, 9/4/2007 11:30:07 AM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SHUT-OFF VALVE SHAFT

Job Number: 34411

Part Number: D34705

Job Number:



Seq. #:

Machine Or Operation:

Description :

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: GA

8/3 07/10/22

(6)

8.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

12/17/10/23

(6)

Job Completion



u 07.10.23

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

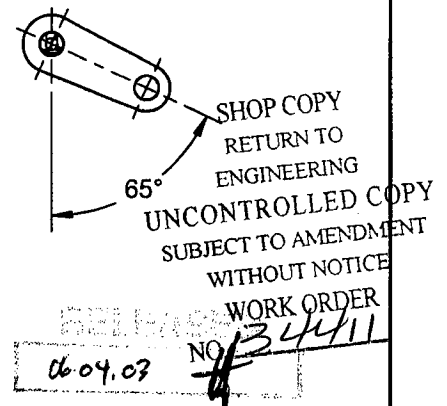
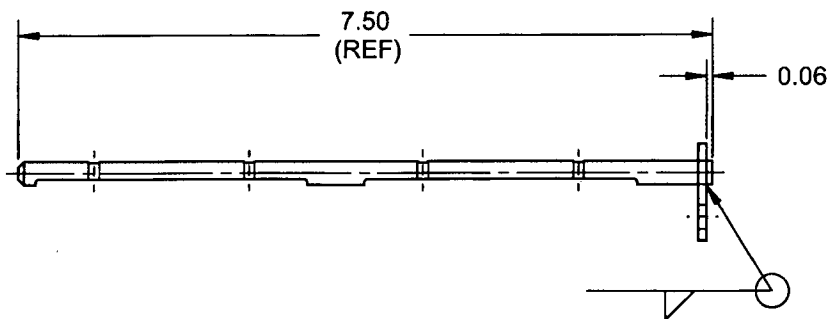
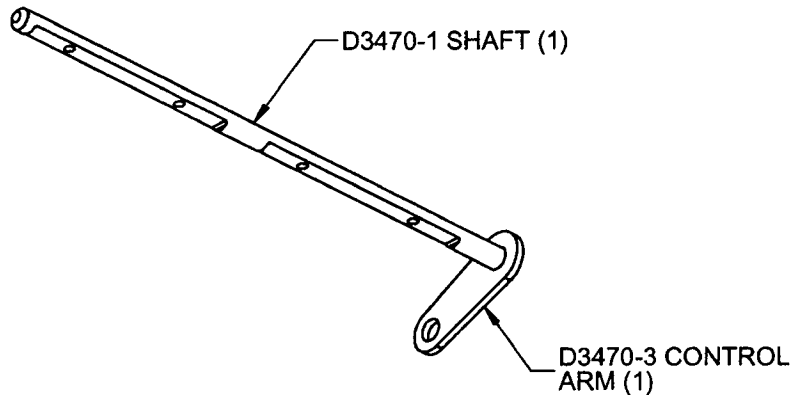
QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**DART**

DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. <b>D3470</b>	REV. A SHEET 1 OF 4
DATE <b>05.12.14</b>		TITLE <b>SHUT-OFF VALVE SHAFT</b>	SCALE 1:2
A	05.12.14	NEW ISSUE	

**D3470-041 SHUT-OFF VALVE SHAFT****NOTES:**

- 1) WELD PER DART QSI 004
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

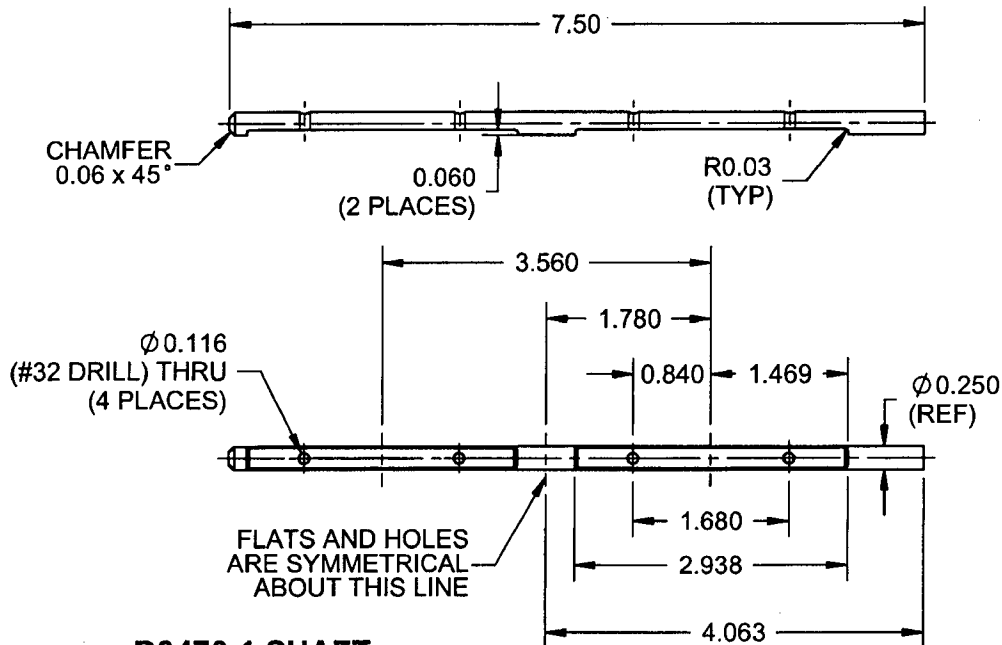
QTY -041	P/N	DESCRIPTION
X	D3470-041	SHUT-OFF VALVE SHAFT
1	D3470-1	SHAFT
1	D3470-3	CONTROL ARM

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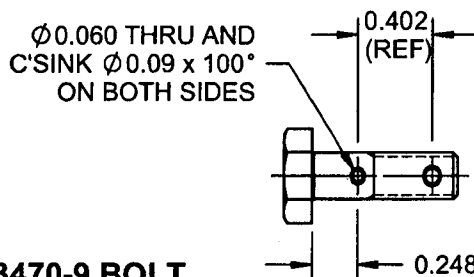
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DATE <b>05.12.14</b>		TITLE <b>SHUT-OFF VALVE SHAFT</b>	SCALE 1:2

**D3470-1 SHAFT**

- 1) MATERIAL: AISI 303 STAINLESS STEEL 0.25 ROUND BAR  
(REF. DART SPEC. M303R0.250)

**D3470-9 BOLT**  
SCALE 1:1

- 1) MAKE FROM AN4-6 BOLT

**NOTES:**

- 2) FINISH: NONE  
3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED  
4) ALL DIMENSIONS ARE IN INCHES  
5) BREAK ALL SHARP EDGES 0.005 TO 0.010

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WORK ORDER  
34411

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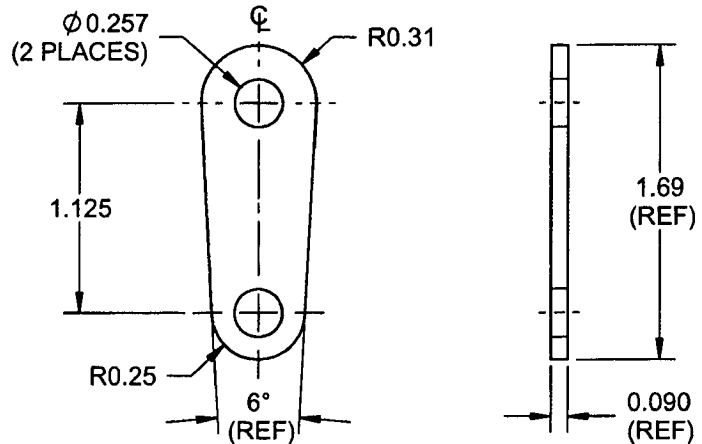
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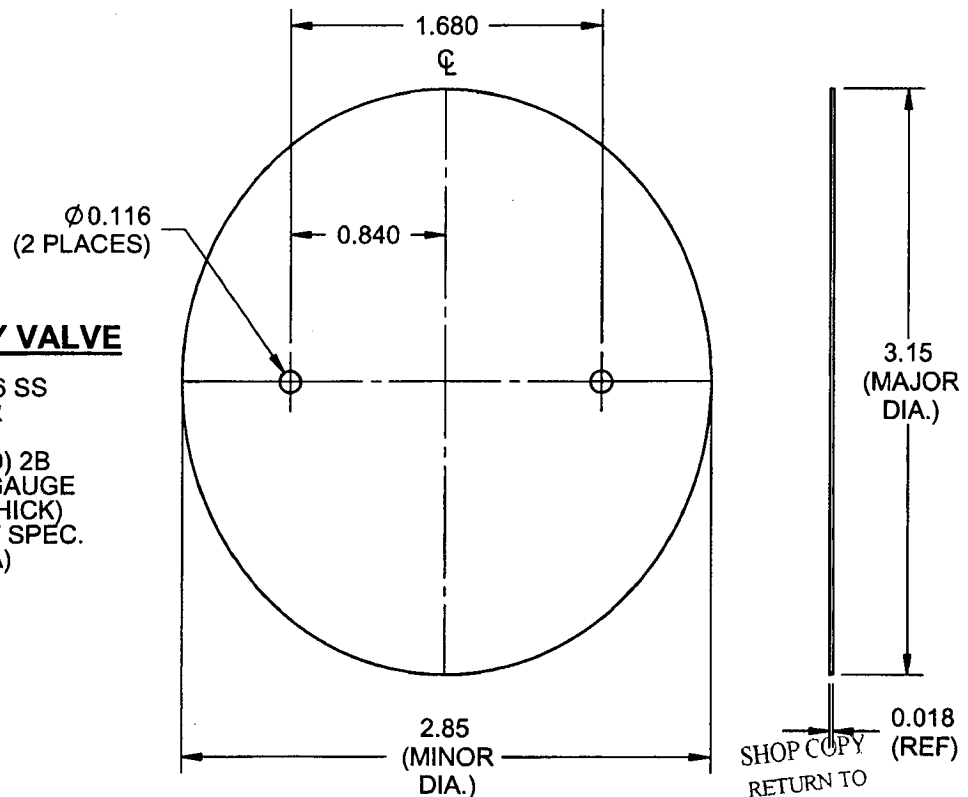
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DATE <b>05.12.14</b>		TITLE <b>SHUT-OFF VALVE SHAFT</b>	SCALE 1:1

**D3470-3 CONTROL ARM**

- 1) MATERIAL: AISI 304/316 SS SHEET PER  
MIL-S-5019 (ANNEALED) 2B  
FINISH 13 GAUGE SS  
(0.090 THICK)  
(REF. DART SPEC. M304S13GA)

**D3470-5 BUTTERFLY VALVE**

- 1) MATERIAL: AISI 304/316 SS  
SHEET PER  
MIL-S-5019  
(ANNEALED) 2B  
FINISH 26 GAUGE  
SS (0.018 THICK)  
(REF. DART SPEC.  
M304S26GA)

**NOTES:**

- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

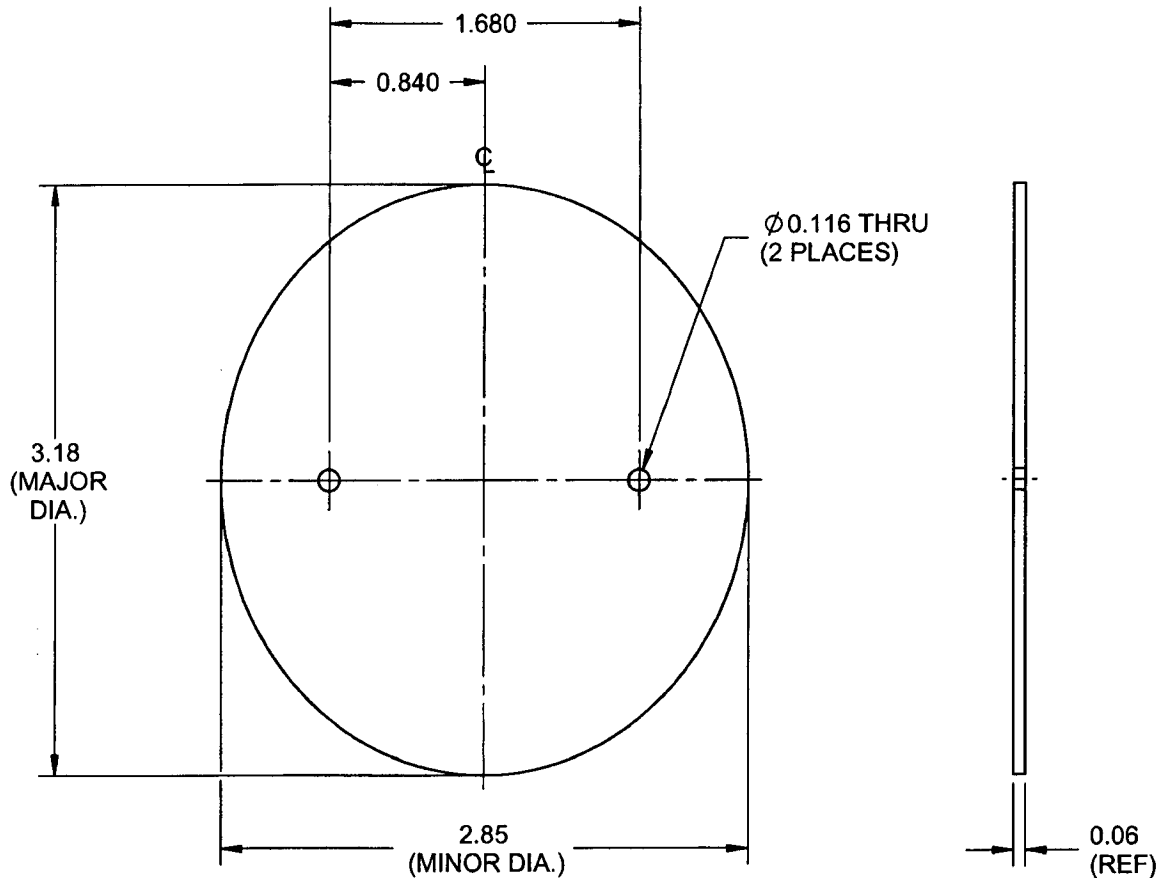
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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3470	REV. A SHEET 4 OF 4
DATE 05.12.14		TITLE SHUT-OFF VALVE SHAFT	SCALE 1:1

**D3470-7 BUTTERFLY VALVE SEAL****NOTES:**

- 1) MATERIAL: RED (OR GRAY) 60 DUROMETER HI-TEMPERATURE SILICONE SHEET, 0.063 THICK (REF. DART SPEC. M-SIL60-S.063)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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06-09-03 *[Signature]*

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NO. 34411



DART AEROSPACE LTD	Work Order:	34411
Description: SHUT OFF VALVE	Part Number:	D3470-5
Inspection Dwg: D3470 Rev: A		Page 1 of 1

# FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article      ☐ Prototype

[illegible]

Measured by: IB	Audited by: S	Prototype Approval: MA
Date: 07-09-06	Date: 07/09/06	Date:

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	